

D6101-003



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D2665-1

Job Sheet 215024



Part No: D2665-1

Job Qty: 4 pcs

Part Name: Saddle, LH Fwd Aft Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/20

Job Tracking No:

Due Date: 12/4/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D
07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs			0.00	0.00	HAAS - 1		DIP 20-11-14
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	4 pcs			1.00	6.15	HAAS - 1 - B4B		DIP 20-11-15
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	4 pcs			0.00	0.67	Conventional Mill - 1 - B4B		DIP 20-11-15
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



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Container No: S311721



Part: D2665-1

Job No: 215024

Serial No/Batch: S311721

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

De

Plex 11/4/20 1:57 PM Dart.lajeunesse.marie

			QC 2 - 49	
			QC 2 - 50	
			QC 2 - 51	
			QC 2 - 52	
			QC 2 - 57	
			QC 2 - 62	
			QC 2 - 63	
			QC 2 - 8	
			QC 2 - 66	
			QC 2 - 64	
			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	QSP 20-11-15
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 2 - 83	
130 QC 8	4 pcs	0.00 0.00	QC 8 - 12	
			QC 8 - 14	QSP 20/11/22
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
140 Handfinish - 1-1 Chemical- B4B	4 pcs	0.00 0.28	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	

			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	DAS
			Handfinish - 1 - 21 - B4B	47 NOV 27 2020
			Handfinish - 1 - 22 - B4B	9-89
150 Powdercoat - 1 White GI(A)- B4B	4 pcs	0.00 0.20	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	20-11-30 8:38
			Powdercoat - 4 - B4B	
			Powdercoat - 5 - B4B	
			Powdercoat - 6 - B4B	
			Powdercoat - 7 - B4B	
			Powdercoat - 8 - B4B	
			Powdercoat - 9 - B4B	
			Powdercoat - 10 - B4B	
160 QC 3	4 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	DEC 01 2020 DAS 40 89
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
			QC 3 - 87	
			QC 3 - 47	
170 Packaging 3-1 - Stock - B4B	4 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	DEC 01 2020 DAS 80 89
			Packaging 3 - 4 - B4B	5402
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	

			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
180 QC 21 - SA	4 pcs	0.00 0.00	QC 21 - SA - 21	DAS 21 DEC 01 2020
			QC 21 - SA - 70	9-88
			QC 21 - SA - 9	
			QC 21 - SA - 77	
			QC 21 - SA - 28	

Part Op 100 - HAAS CNC Vertical Machine Program batch number. 1- Inspect part number and batch number are programmed Descriptions: correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - QC3- Inspect Part Finish Standard Process
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	90-Machining - Issue SN	5296733

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-003	4	11	0

Part Specifications

Specifications could not be found.

Plex 11/4/20 1:57 PM Dart.lajeunesse.marie

DART AEROSPACE LTD				Work Order: 215024	
Description: 206 Saddle, Outboard, Left side				Part Number: D2665-1	
Inspection Dwg: D2665 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.123	0.123	0.123	0.122	
B	0.100	0.140		0.131	0.127	0.127	0.126	
C	1.125	1.145		1.135	1.135	1.135	1.135	
D	0.615	0.685		0.660	0.666	0.660	0.660	
E	0.240	0.260		0.250	0.244	0.251	0.252	
F	1.313	1.343		1.323	1.317	1.324	1.324	
G	0.210	0.230		0.220	0.220	0.2205	0.220	
H	0.100	0.180		0.140	0.140	0.140	0.140	
I	2.470	2.510		2.500	2.500	2.500	2.500	
J	1.565	1.585		1.575	1.575	1.575	1.575	
K	0.235	0.240		0.238	0.238	0.238	0.238	
L	0.100	0.120		0.113	0.113	0.113	0.113	
M	0.990	1.010		1.000	1.000	1.000	1.000	
N	0.510	0.515		0.512	0.512	0.512	0.512	
O	5.990	6.010		6.000	6.000	6.000	6.001	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		0.313	0.313	0.313	0.313	
S	0.315	0.322		0.316	0.316	0.316	0.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		0.794	0.794	0.794	0.794	
W	0.540	0.560		0.548	0.548	0.549	0.549	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.923	0.924	0.925	0.925	
AA	0.490	0.510		0.502	0.505	0.505	0.506	
AB	0.178	0.198		0.188	0.188	0.188	0.188	
AC								
AD								
AE								
Accept/Reject								

Measured by: DIP	Date: 20-11-14
Audited by: JMK	Date: 20/11/22
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	M

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					